

Date: Thursday, 11/29/2007 11:00:06 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	CROSSBOLT SPACER	
Job Number	36013					
Estimate Number	11010					
P.O. Number	:			Part Number	D2649	
This Issue	11/29/2007	S.O. No.	:	Drawing Number	D2649 REV B1	
Prsht Rev.	NC			Project Number	N/A	
First Issue	/ /	Type	MACHINED PARTS	Drawing Revision	B1	
Previous Run	34612			Material	:	
Written By	:			Due Date	12/10/2007	Qty: <u>300</u> Um: Each
Checked & Approved By	<u>11/07.11.29</u>					
Comment	Est F 02.03.26 Added turning on Cobra NG					
Additional Product						
Job Number: 						
Seq. #:	Machine Or Operation:	Description :				
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W 				
Comment: Qty.: 0.2975 f(s)/Unit Total : 89.23951(s) 6061-T6 Tube .375 x.058W Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall			M103 841 M105 041		M106469 M104897 Batch _____	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 				
Comment: HARDINGE CNC LATHE SMALL Machine as per folio <u>FA214</u> on cobra machine.			07/12/10 H.A./sc			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 				
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			07/12/10 H.A./sc			
4.0	QC8	SECOND CHECK 				
Comment: SECOND CHECK			07/12/13 395			
5.0	PACKAGING 1	PACKAGING RESOURCE #1 				
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>LG</u>			RE 07/12/13			
6.0	QC21	FINAL INSPECTION/W/O RELEASE 				
Comment: FINAL INSPECTION/W/O RELEASE			2007/12/18 W			
Job Completion						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36013
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

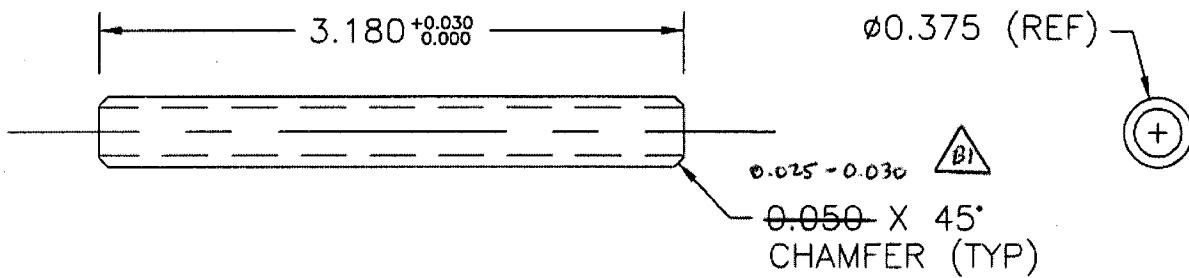
Measured by:	<u>H.A. / ZB</u>	Audited by:	<u>Amf</u>	Prototype Approval:	N/A
Date:	07/12/10	Date:	07/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	TT



DESIGN <i>DWY</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DWY</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# CP 02.06.13	REDUCE CHAMFER PER TSR 1206.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)

0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36013*